

Work Order ID 53205

October 26, 2009 12:43:14 PM



Page 1

Item ID:	D2512	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Basket Lid.205/350					
Start Date:	26/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-10-26	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2512	Rev E								

100
 Weld per dwg A/R S.S. rod Batch: M109213 0.00
Large Fab
Large Fab
Memo 0.00
1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

110
 QC9- Inspect visual per QSI004- Fusion Welds 0.00
QC
Memo 0.00
Quality Control

SY 09/10/29 (1x)






Cpl 09 10 29



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



Page 2

Item ID: D2512 Accept  Setup Start 
Revision ID: E Stop 
Item Name: Basket Lid 205/350
Start Date: 26/10/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 04/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120  QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00 ⇒ 5 or 10/30							
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130  Powdercoat Powder Coating	Pressure-Wash White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M1112248 Memo 1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat	0.00 0.00 20 09/11/05				21	Ø		
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1ST COAT:
START TIME: 11:30am
OVEN TEMPERATURE: 400°F
FINISH TIME: 12:09pm

2ND COAT:
START TIME: 12:45pm
OVEN TEMPERATURE: 400°F
FINISH TIME: 1:15pm



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Item ID: D2512 Accept  Setup Start 
Revision ID: E Stop 
Item Name: Basket Lid 205/350
Start Date: 26/10/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 04/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  HandFinish	HandFinishing	0.00							
Hand Finishing	Memo <i>M112437 BLACK</i> Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: <i>M112/00</i>	0.00					<i>0.</i>		
150  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00				<i>21</i>			
160  Packaging	Identify as per dwg & Stock Location: <i>PMP</i>	0.00							
Packaging	Memo	0.00				<i>53188</i>			<i>P0911/05</i>



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


Page 4

Item ID: D2512 Accept  Setup Start 
Revision ID: E Stop 
Item Name: Basket Lid 205/350
Start Date: 26/10/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 04/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/11/05 
PL 09-11-5

Picklist Print

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Work Order ID: 53205

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	24.0000	2.0000			

Clevis

Handwritten: A mk

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	24	
31101	2	
52498	22	

ONLY APPLICABLE ON D130-701-117

D2232-1RevC

Manufactured

No

100

Each

26.0000

2.0000

Basket Hinge

Handwritten: ✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	24	
50896	4	
51105	20	

Handwritten: 2x 09/10/28

Picklist Print

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Work Order ID: 53205



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	41.0000	2.0000			

Spacer Bushing

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	41	
51331	16	
52832	25	

OK 24/09/10/28

D2506RevF

Manufactured No

100

Each

13.0000

1.0000



Label Plate

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
44275	1	
Main Warehouse		
WA	12	
51303	2	
52834	10	

1x 24/09/10/28

Picklist Print

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Work Order ID: 53205



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1 		Manufactured	No			100	Each	66.0000	2.0000			
Mounting Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 13

46086 2

48428 1

51120 10

Main Warehouse

WA 53

50872 4

51745 49

D3166-3RevA1

Manufactured No

100

Each

11.6210

1.0000



Basket Hoop

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 11.621

50033 0.0527

50618 0.5683

51249 5

52058 6

2x 14/09/10/08
SAD 09-10-27

Picklist Print

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Work Order ID: 53205

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350


Comments:

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ M304EX0.75-16F  Expanded Metal Flat SS		Purchased	No			100	sf	476.5700	18.9474		<u>SAD 09-10-28</u>	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	476.5700065	
110134	3.4	
111630	5.85	<u>2.00</u>
111956	0.000017	
112147	8.29428947	
112311	28.9205	
112707	110.1052	<u>16,9474</u>
112949	320	

✓ M304TS0.750W.065

Purchased

No

100

f

460.8319

45.8741



304 SQ Tube .75x.75x.065W

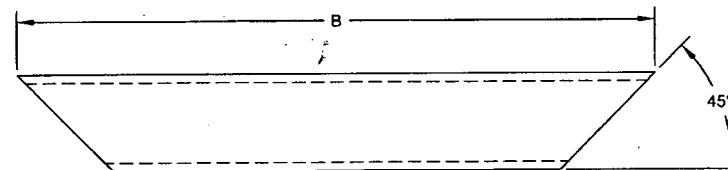
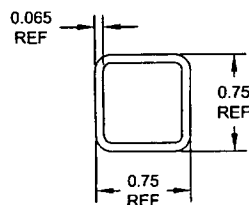
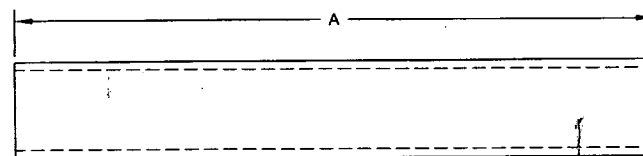
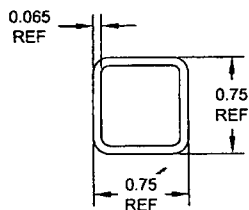
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	460.8318947	
112398	460.831895	<u>45.8741</u>

End Bar Scrap B#112398 Qty ~~1.2~~ 1.2 sq (ft)

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

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NO. 53205
B/0910-26

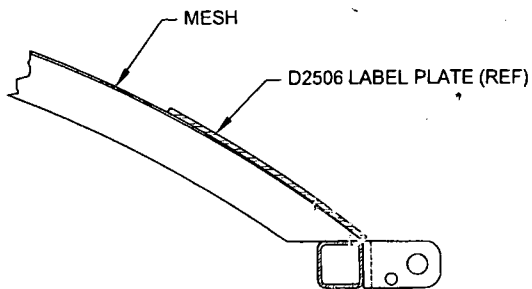


RELEASED
08-06-21

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT. AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND IS CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D2512-1/-3/-5/-7 NOTES:

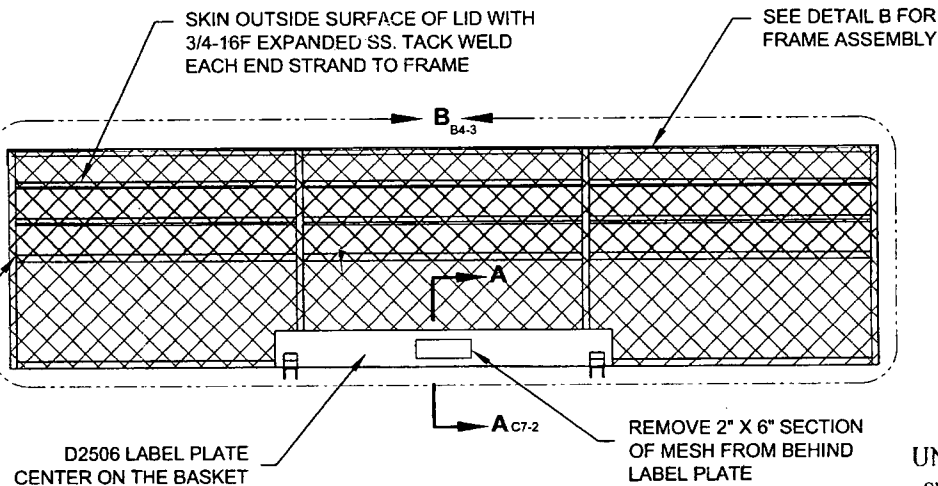
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST



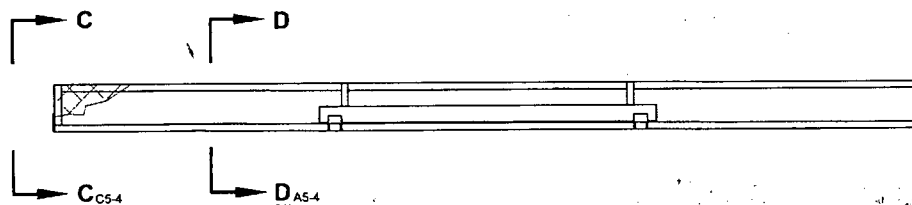
SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



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WORK ORDER
NO. 53205

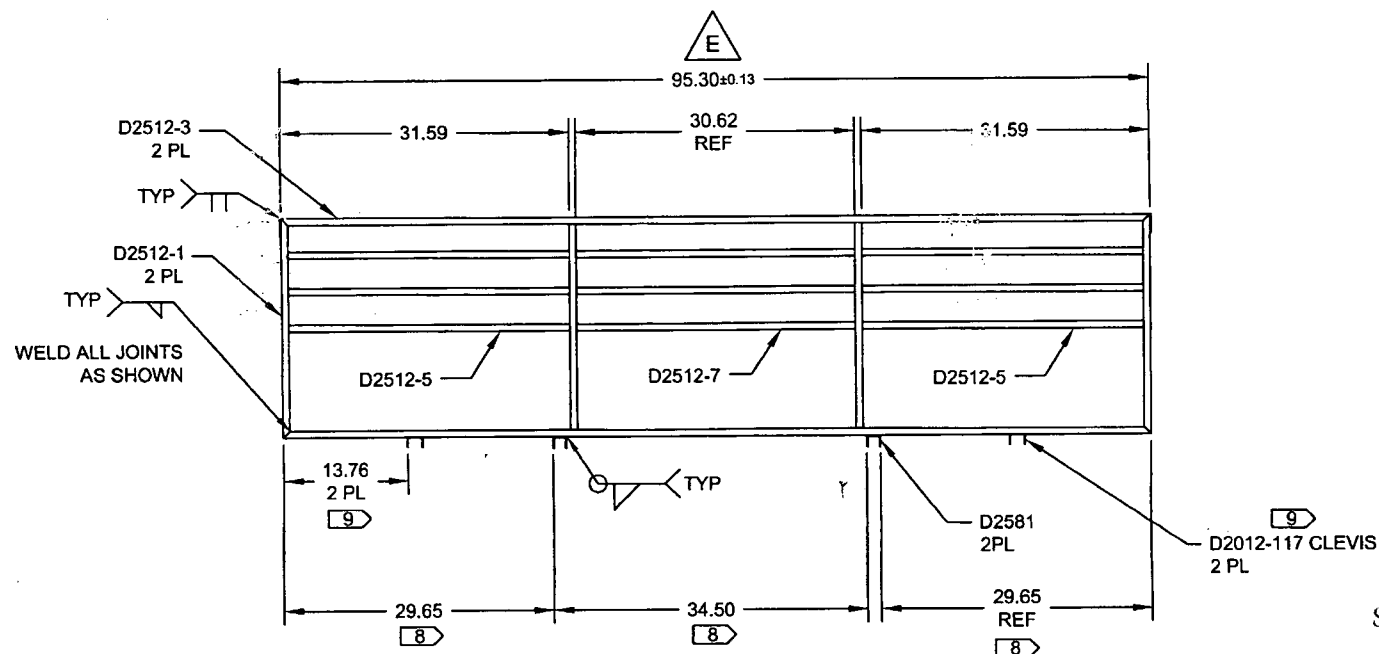


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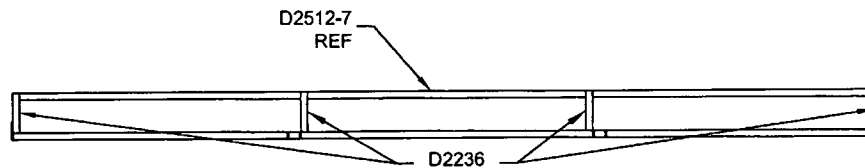
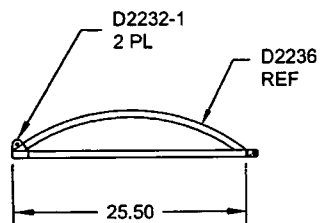
D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



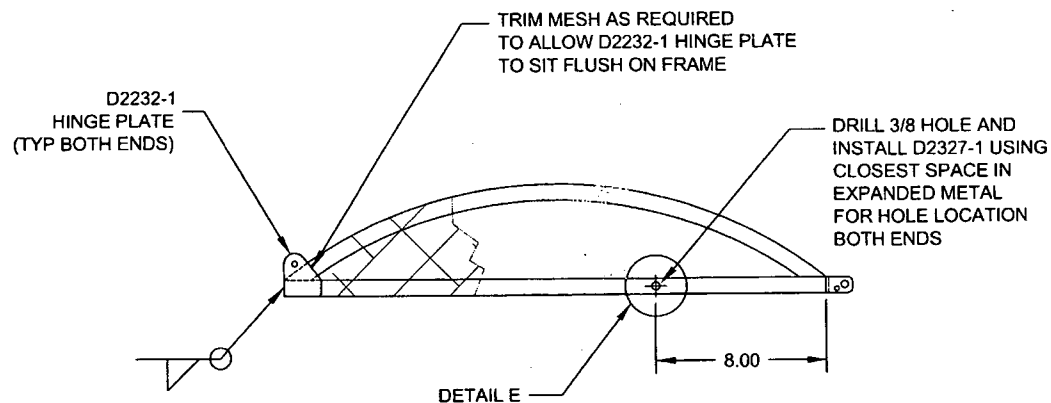
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WORK ORDER NO. 53205

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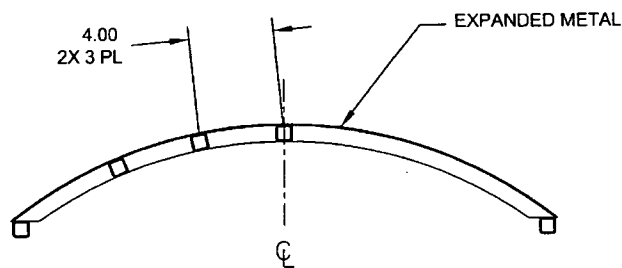
- NOTES:**
- MATERIAL: NONE
 - FINISH: NONE
 - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - UNITS: INCHES UNLESS OTHERWISE NOTED
 - BREAK SHARP EDGES: N/A
 - IDENTIFICATION: NONE
 - WEIGHT: N/A
 - LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

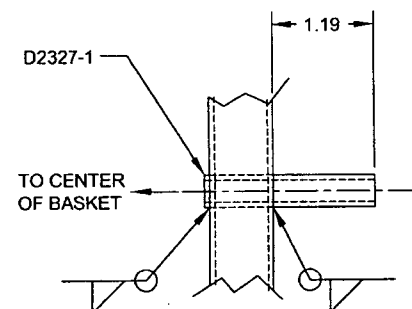


VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1